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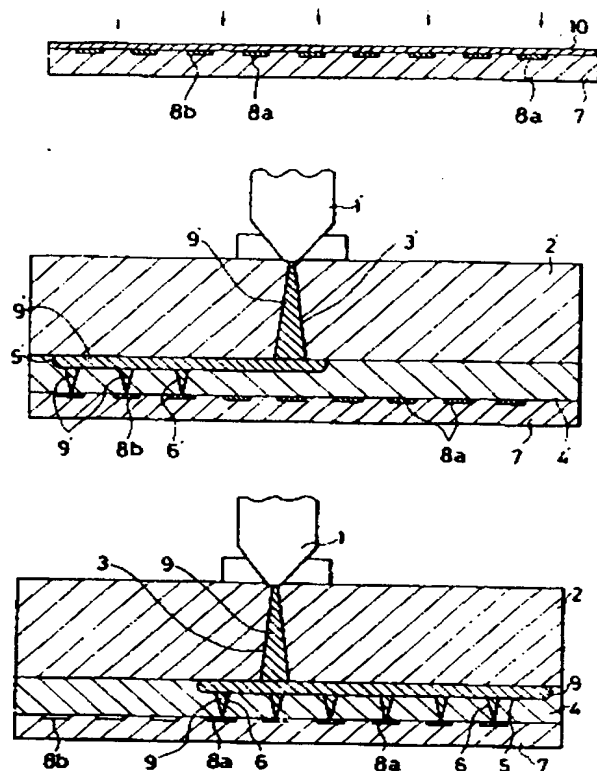
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TITLE : MOLDING PROCESS OF
MULTI-COLORED THICK PATTERN



ABSTRACT : **PURPOSE:** To obtain a multicolored thick pattern adjacent to each other by a method in which the concave grooves of the engraved intaglio provided with the concave grooves corresponding to the multicolored thick pattern are filled with the colored polyvinyl chloride containing the foaming agents correspondingly to the individual color, and then a base material is pressure welded thereon and heated, thereby transferring said polyvinyl chloride onto said base material.

CONSTITUTION: The colored polyvinyl chloride sol 9 containing the first foaming agent is injected and packed into a specified concave grooves 8a. After the filler resin 9 has been suitably solidified, an engraved intaglio 7 is separated from the first runner plate 4 and is pressure welded to the back surface of the second runner plate 4'. Then, the colored polyvinyl chloride sol 9' containing the second foaming agent is injected and packed into a specified concave grooves 8b. After the filler resin 9' has been suitably solidified, the engraved intaglio 7 is separated from the second runner plate 4' and a base material 10 is lapped thereon, and then are pressurized with heating, thereby transferring and sticking said vinyl chloride 9, 9' onto the base material 10. Thus, the multicolored thick pattern may be molded.

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